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Patent Claims

1. An assembly support for a vehicle door (1) equipped with a locking system (8), in particular of a passenger vehicle, the assembly support (5) being designed for fastening to the body shell (2) of the vehicle door (1) and a lock unit (6) of the locking system (8) being fastened to it,
characterized
in that an outside actuating unit (9) of the locking system (8) is fastened to the assembly support (5) and/or to the lock unit (6), the lock unit (6) and the outside actuating unit (9) being coupled to each other via an operative connection (12).

2. The assembly support as claimed in claim 1,
characterized
in that the outside actuating unit (9) is designed in such a manner that, with the assembly support (5) fastened to the body shell (2), an outside door handle (10) of the locking system (8) can be fastened from an outer side of the vehicle door (1) through an outer skin of the body shell (2) to the outside actuating unit (9).

3. The assembly support as claimed in claim 1 or 2,
characterized
in that the lock unit (6) is fastened to the assembly support (5) by means of a first adaptor (7).

4. The assembly support as claimed in one of claims 1 to 3,
characterized
in that the outside actuating unit (9) is fastened to the assembly support (5) and/or the lock unit (6) by means of a second adaptor (11).

5. The assembly support as claimed in one of claims 1 to 4,
characterized
in that the fastening of the lock unit (6) to the assembly support (5) and/or of the outside actuating unit (9) to the assembly support (5) and/or to the lock unit (6) is designed in such a manner that the lock unit (6) and/or the outside actuating unit (9) can be positioned within a predetermined range of tolerances.

6. The assembly support as claimed in one of claims 1 to 5,
characterized
in that the functionality of the lock unit (6), outside actuating unit (9) and operative connection (12) is tested and adjusted when the assembly support (5) is finished and has not yet been fitted into the vehicle door (1).

7. A method for assembling a vehicle door (1) equipped with a locking system (8), in particular of a passenger vehicle,
having the following steps:
- fastening a lock unit (6) of the locking system (8) to the assembly support (5) and an outside actuating unit (9) of the locking system (8) to the assembly support (5) and/or to the lock unit (6) and coupling the lock unit (6) to the outside actuating unit (9) by means of an operative connection (12),
- adjusting and testing the mounted locking system (8),
- fitting the assembly support (5) into a body shell (2) of the vehicle door (1),
- attaching an outside door handle (10) of the locking system (8) to the outside actuating unit (9) from an outer side of the vehicle door (1) through an outer skin of the body shell (2).

8. The method as claimed in claim 7, characterized in that a reference outside door handle is used for adjusting and testing the locking system (8) while, with the assembly support (5) fitted into the body shell (2), a standard outside door handle (10) is used for attaching to the outside actuating unit (9).

9. The method as claimed in claim 7 or 8, characterized in that when the lock unit (6) is fastened to the assembly support (5) and/or the outside actuating unit (9) is fastened to the assembly support (5) and/or to the lock unit (6) a rough positioning of the lock unit (6) and the outside actuating device (9) takes place while, when the assembly support (5) is fitted into the body shell (2), a fine positioning of the lock unit (6) and the outside actuating unit (9) takes place.

10. The method as claimed in one of claims 7 to 9, characterized in that the lock unit (6) and the outside actuating unit (9) are transferred in each case into a reference position for the adjustment and testing.

11. The method as claimed in one of claims 7 to 10, characterized in that for the adjustment and testing use is made of an adjusting and testing device which permits an alignment of the lock unit (6) and of the outside actuating unit (9) in their reference positions.

12. The method as claimed in one of claims 7 to 11, characterized in that the lock unit (6) and/or the outside actuating unit (9) is/are additionally fastened to the body shell (2) when the assembly support (5) is fitted.

13. The method as claimed in one of claims 7 to 12, characterized
in that the adjustment and testing of the locking system (8) takes place within the context of a preassembly process of the assembly support (5) while the fitting of the assembly support (5) and the attaching of the outside door handle (10) take place within the context of a final installation which is independent or temporally and/or locally decoupled from the preassembly process.

14. An adjusting and testing device for carrying out the method as claimed in claim 11, characterized by aligning elements for aligning the lock unit (6) and the outside actuating unit (9) in their reference positions.